Date:

Tuesday, 12/08/2008 1:01:18 PM

CUser:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Drawing Name

: CUP

Job Number

: 41176-

Estimate Number

: 13106

P.O. Number

: 12/08/2008

Part Number

This Issue

: D30093

Prsht Rev.

·: NC

Drawing Number

. D3009 REV B

Project Number

First Issue

: //

Drawing Revision

: N/A ; B

: 41075 **Previous Run**

Material **Due Date**

: 30/08/2008

Written By

Comment

Checked & Approved By

: Est. A 07.12.18 new issue

: MACHINED PARTS

Est Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD veryfied

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

by:ec

Description:

1.0

M304R1000

304 round bar 1.00

Comment: Qty.:

0.0503 f(s)/Unit Total: 2.0118 f(s)

304/316 SS ROUND BAR

Material: AISI304/316 SS 1.00" Ø Round Bar

(M304R1000)

2.0

HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA130 & DWG D3009 FOLIO REV:

DWG REV:

2-DEBURR AS REQUIRED

3.0

QC2

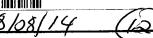
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK



5.0

PACKAGING 1

PACKAGING RESOURCE #1

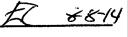


Comment: PACKAGING RESOURCE #1

Identify and Stock

41111 Location:

412 ski wearplate



Date:

Tuesday, 12/08/2008 1:01:18 PM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 41176

Part Number: D30093

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

TELEMOL

(G)

_

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mF 08-08-14

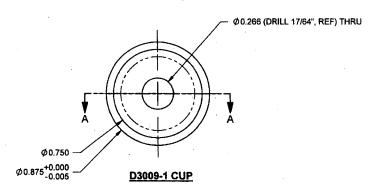
DART AEROSPACE LTD Description: Cup					Work Order: 41170		
					Part Number:	D3009-3	
Inspection Dwg: D3009 Rev: B					Page 1 of 1		
		ARTICLE IN	ISPECTI	ON CHE	CKLIST		
	X	First Artic	cle 🗀	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
Ø0.875	+0.000/-0.005	6.875	/				
Ø0.750	+0.008/-0.001	0,750					
Ø0.266	+0.006/-0.001	0,267					
R0.062	+/-0.010	R.062	/				
0.094	+/-0.010	,093					
0.353	+/-0.010	354					
0.063	+/-0.010	.062					
R0.032 x 45°	+/-0.010	ROJENS					
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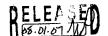
Measured by:	Audited by: J.F.	Prototype Approval:	N/A
Date: 08/08/14	Date: 08/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.01.22	New Issue	KJ/EC/DD	77
L			1.()	

R0.062 -R0.032 x 45° CHAMFER 0.094 0.353 0.063 (REF)

SECTION A-A





В	REDRAWREFORMAT DWG, D3009-1 MATL WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2)				07.12.12	
Α	NEWISSUE			RF	01.03.23	
REV.		DESCRIPTION			DATE	
DESIG	DESIGN (2)		DART AEROSPACE LTD			
DRAW	DRAWN (1)		HAWKESBURY, ONTARIO, CANADA			
CHECKED MFG, APPR.		'A	DRAWING NO.		REV. B	
		17	□ D3009		SHEET 1 OF 2	
APPRO	APPROVED		TITLE		SCALE	
DE APPR.		-4	↑CUP	2:1		
DATE 07.12.12			COPYRIGHT © 2001 BY DART AEROSPACE LTD. THIS DOCUMENT IS MINITE AND COMPERTURE. AND IS EMPLIED ON THE EXTRESS GONOMINETAT IT IS HOT TO BE USED FOR ANY PURPOSE OR COMPLIENCE OF ONLY OTHER PERSON WITHOUT WRITTEN PREMISSION FROM DIVIT MARGINECE LTD.			

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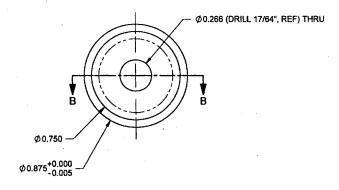
С

NOTES:
1) MATERIAL:AISI 1018-1025 ROUND BAR
(REF DART SPEC M1018-R)
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

SHIOP COPY

ENGINEERING
ENGINEERING
UNICONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK, ORDER

R0.062 -R0.032 x 45* CHAMFER 0.094 0.353 0.063 (REF) SECTION B-B



SHOP COPY
RETURN TO
RETURN TO
REMOINEERING
ENGINEERING

D3009-3 CUP

NOTES:
1) MATERIAL:AISI 304/316 STAINLESS STEEL ROUND BAR (REF DART SPEC M304R)
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

DESIGN	91	DART AEROSPACE LTD	
DRAWN	a	HAWKESBURY, OF	TARIO, CANADA
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	· Jr.	D3009	SHEET 2 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	-#	CUP	2:1
DATE 07.1	2.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT BY PARTIE AND OUR PORTHER, AND IS SEPPLED ON THE EXPLICATION THAT IT IS NOT TO BE LIFED FOR ANY PARTIES ON CORNEL ON COMMUNICATION TO ANY CHEST PERSON WITHOUT	